

§ 195.208

transportation is performed in accordance with API RP 5LT (incorporated by reference, *see* §195.3).

[Amdt. 195-94, 75 FR 48606, Aug. 11, 2010, as amended by Amdt. 195-99, 80 FR 186, Jan. 5, 2015]

§ 195.208 Welding of supports and braces.

Supports or braces may not be welded directly to pipe that will be operated at a pressure of more than 100 p.s.i. (689 kPa) gage.

[Amdt. 195-22, 46 FR 38360, July 27, 1981, as amended by Amdt. 195-63, 63 FR 37506, July 13, 1998]

§ 195.210 Pipeline location.

(a) Pipeline right-of-way must be selected to avoid, as far as practicable, areas containing private dwellings, industrial buildings, and places of public assembly.

(b) No pipeline may be located within 50 feet (15 meters) of any private dwelling, or any industrial building or place of public assembly in which persons work, congregate, or assemble, unless it is provided with at least 12 inches (305 millimeters) of cover in addition to that prescribed in §195.248.

[Amdt. 195-22, 46 FR 39360, July 27, 1981, as amended by Amdt. 195-63, 63 FR 37506, July 13, 1998]

§ 195.212 Bending of pipe.

(a) Pipe must not have a wrinkle bend.

(b) Each field bend must comply with the following:

(1) A bend must not impair the serviceability of the pipe.

(2) Each bend must have a smooth contour and be free from buckling, cracks, or any other mechanical damage.

(3) On pipe containing a longitudinal weld, the longitudinal weld must be as near as practicable to the neutral axis of the bend unless—

(i) The bend is made with an internal bending mandrel; or

(ii) The pipe is 12¾ in (324 mm) or less nominal outside diameter or has a diameter to wall thickness ratio less than 70.

(c) Each circumferential weld which is located where the stress during bend-

49 CFR Ch. I (10–1–16 Edition)

ing causes a permanent deformation in the pipe must be nondestructively tested either before or after the bending process.

[Amdt. 195-22, 46 FR 38360, July 27, 1981, as amended by Amdt. 195-52, 59 FR 33396, June 28, 1994; Amdt. 195-63, 63 FR 37506, July 13, 1998]

§ 195.214 Welding procedures.

(a) Welding must be performed by a qualified welder or welding operator in accordance with welding procedures qualified under section 5, section 12 or Appendix A of API Std 1104 (incorporated by reference, *see* §195.3), or section IX of ASME Boiler and Pressure Vessel Code (BPVC) (incorporated by reference, *see* §195.3). The quality of the test welds used to qualify welding procedures must be determined by destructive testing.

(b) Each welding procedure must be recorded in detail, including the results of the qualifying tests. This record must be retained and followed whenever the procedure is used.

[Amdt. 195-38, 51 FR 20297, June 4, 1986, as amended at Amdt. 195-81, 69 FR 32897, June 14, 2004; Amdt. 195-99, 80 FR 186, Jan. 5, 2015; Amdt. 195-100, 80 FR 12780, Mar. 11, 2015]

§ 195.216 Welding: Miter joints.

A miter joint is not permitted (not including deflections up to 3 degrees that are caused by misalignment).

§ 195.222 Welders and welding operators: Qualification of welders and welding operators.

(a) Each welder or welding operator must be qualified in accordance with section 6, section 12 or Appendix A of API Std 1104 (incorporated by reference, *see* §195.3), or section IX of ASME Boiler and Pressure Vessel Code (BPVC), (incorporated by reference, *see* §195.3), except that a welder or welding operator qualified under an earlier edition than an edition listed in §195.3, may weld but may not re-qualify under that earlier edition.

(b) No welder or welding operator may weld with a welding process unless, within the preceding 6 calendar months, the welder or welding operator has—

(1) Engaged in welding with that process; and